

SPLIT

Dart Aerospace Ltd.

Date: Monday, 3/26/2007 3:23:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING
 Job Number : 31489
 Estimate Number : 10608
 P.O. Number : N/A Part Number : D2655
 This Issue : 3/26/2007 S.O. No. : N/A Drawing Number : D2655 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 29334 Material : N/A
 Due Date : 4/30/2007 Qty: 20 U/m: Each
 Written By :
 Checked & Approved By :
 Comment : Est. D 00 06 22 Removed P/O for powder coat EC
 Est Rev:E Now on Waterjet 06-10-04 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1018B400X250

Inventory



Comment: Qty.: 0.2835 f(s)/Unit Total : 5.6700 f(s)

1018 ASTM A36 .250" thk bar x 4.0"

Batch: M104852X HB 07-06-27

(20)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2655

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

HB 07-06-28

(20)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-06-28

(20)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

HB 07-06-28

(20)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble - .030 Radius

2-Deburr any rough edges after tumbling

HB 07-06-29 (20)

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Drawing Name: RING

Job Number: 31489

Part Number: D2655

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Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

corn 10
En 07/06/29 (420)

7.0

~~POWDER COATING~~

spray painting

POWDER COATING



Comment: ~~POWDER COATING~~

~~Powder Coat per QSI 005 4.3.5.1~~

Deflect Blue
+ clear

Helier Delassette

Issue 1.0 4105 C20107105 (2)

8.0

QC5

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/7/09 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/7/11 SP (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2)
07/15/24

Job Completion

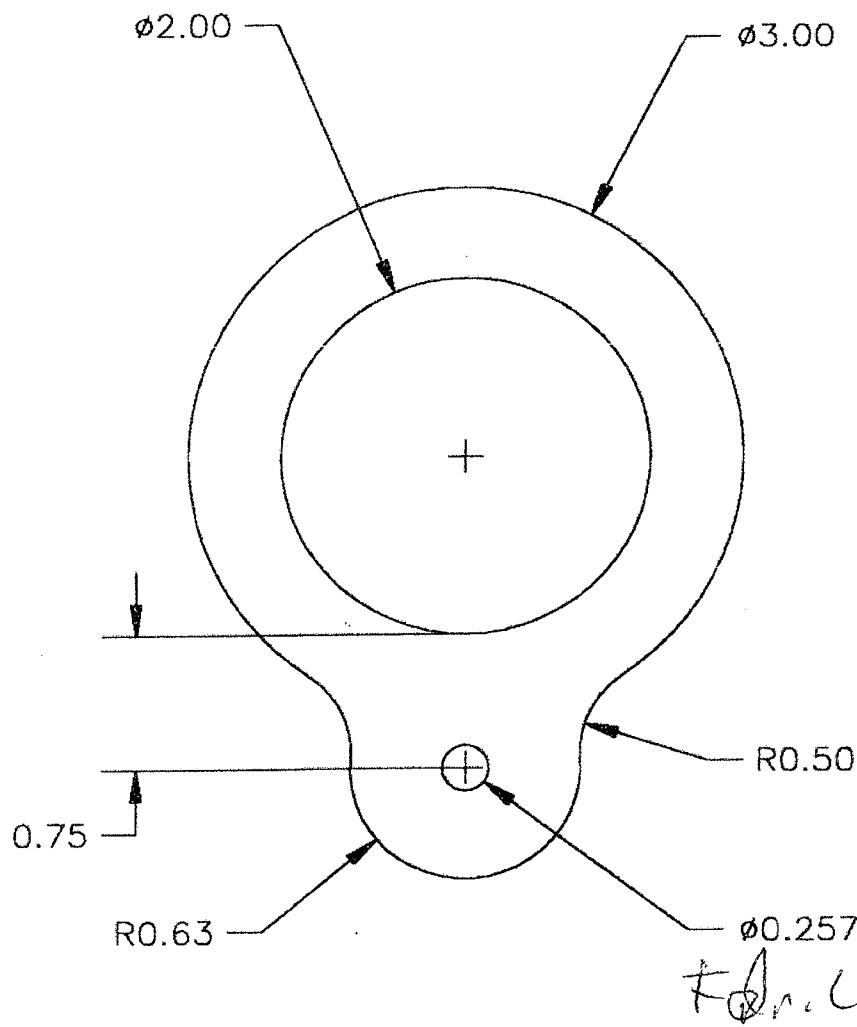


u 07-07-24



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2655 | REV. B SHEET 1 OF 1 |
| DATE 97:07:07 | | TITLE RING | SCALE 1:1 |
| A | 97:03:25 | NEW ISSUE | |
| B | 97:07:07 | ADD ASTM A36 TO MAT. SPEC. | |

RELEASED
47/07/11 DS



NOTE: DEBURR ALL SHARP EDGES
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK
FINISH: POWDER COAT PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ALL RIGHTS
RESERVED
WORK ORDER
NO 31489

